

January 5, 2010 8:03:27 AM

Required Date: 18/01/2010

Item ID:

Accept D117-762-041

Setup Start

Stop

Revision ID: Item Name:

Replacement Skidtube

Start Date:

05/01/2010

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

Date 0-1-05 Tooling:

Date:

Rev.

Start



Approvals:

SPC (Y/N):

Date:

Stop



Sequence ID/

Operation

Set Up/

Draw

Plan

Accept Qty

Reject

Work Center ID

Description

Run Hours

Number

Draw Code

Qty

Run

Reject Number

insp. Stamp

Draw Nbr

Revision Nbr

D3582

Rev A

100

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041

CHG001

110

Skidtubes

0.00

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr 2-Drill #30 pilot holes using DT8678.

3- open holes to 5/16"

0.00

120

CNC Bend 1

BENDING MACHINE - SKIDTUBES

Meme

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Use 5/16"

locator pin on buggy "A".

Dart Aerospace Li	la
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W/O:		WORK ORDER (WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
-											
		•. •									
Part No) :	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					

Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B				Ammunial				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

Resolution:

Work Order ID 54881

January 5, 2010 8:03:27 AM

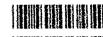
Item ID:

D117-762-041

Accent



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Start Qty: 1.00

Required Date: 18/01/2010

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Qty

Run

Start



Stop



Sequence ID/

Work Center ID

Set Up/ Run Hours Number

Rev.

Plan Code Accept Reject Qty

Reject

Insp. Number Stamp

130



Skidtubes

Skidtubes

Operation Description

0.00

Skidtubes

Memo 1-Cut Fwd end of the tube using DT8185

2-Cut Aft end using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

5-Locate DT 8973 & Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole, then drill all X-Boltholes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.





W/O:			CHANGES		·		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DC	A:	_ Date: _	
	Re	esolution:	Disposition:	QA: N/C	Closed:	11	Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: D	ate & initial a	all entries			THEF I						

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Cust Item ID:

Customer:



Reference:

Approvals:

Required Date: 18/01/2010

Process Plan:

Date:

Tooling:

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

140

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

0.00

0.00

Draw Number

Draw Plan Rev. Code

Qty

Accept Reject Qty

Reject Number Stamp

lasp.

Skidtubes

Memo

I-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: 170 112 60

2-Grind flush

150 QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

Memo

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	:	QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC			on B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	tion C	Chief Eng	QC Inspector
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05/01/2010

Start Qty: 1.00

Required Date: 18/01/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Draw

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ Work Center ID

170

HandFinish Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Qty Code Number Rev.

Plan

Accept

Reject Reject Qty

Insp. Number Stamp

180

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

N 10/1/12

W/O:			WO	RK ORDER CHANG	ES				1
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 54881



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Replacement Skidtube

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Reg'd Qty: 1.00



Cust Item ID:

Customer:



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

190

Skidtubes Skidtubes

Operation Description

Set Up/ Run Hours Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject insp. Number Stamp

Skidtubes

Memo

0.00

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sike Flex Batch: M11 2 3 4CS

Exp Date: 10/8/30

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD

Batch: M112860

6-Grind welds flush

OC10- Inspect visual per QS1004- ground welds

M-h 10/02/16

200

Memo

Quality Control

W/O:				WORK ORDER	CHANGES			-		
DATE	STEP		PROC	CEDURE CHANGE		Ву	Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector
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Part No) :		PAR #:	Fault Category:	NCF	R: Yes	No DQ	۸:	Date:	
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	WORK ORDER NON-CONFORMANCE (NCR)										
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Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Date: Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Date:

Run Start



Stop



Sequence ID/ **Work Center ID**

210



QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Run Hours

Draw Number Rev.

Date:

Plan Code

Qty

Reject Accept Qty

Reject

Insp. Number Stamp

215



Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Memo

=> M 10-01-18





Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

11113130

Memo

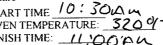
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0.00









W/O:		·	WO	RK ORDER CHA	NGES					
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		Section A	Chief Eng	Chief Eng		Date		ion C	Chief Eng	QC Inspector
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Setup Start

Stop



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Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference: Approvais:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Start Run

Stop



Sequence ID/ Work Center ID

230

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours**

Rev. Number 10-01-20

Date:

Code

Plan

Accept Qty

Reject Qty

Reject Insp. Number Stamp

240

HandFinish

Hand Finishing

Memo

0.00

0.00

0.00

HandFinishing

Memo

0.00

Install Wearplate & Ground Wire inserts as per Dwg D3582

BK 10-01-20

250

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

0.00

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Deta A/R 241 Sika Flex Batch: M. U

3-Install Wearplates as per Dwg D3582

Note:Install Bolt and wa

Wing Welk asper dwg

by 10-01-22 0.

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W/O:			WO	RK ORDER CHANG	SES					· · · · · · · · · · · · · · · · · · ·		
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Part No	•	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	lo DQ	A:	Date:			
	R	esolution:	Disposition	:	QA: N	I/C Clo	sed:		Date: _	···		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR))					
DATE	STEP	Description of NC			tion B		Verification		Verification A		Approval	Approval
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector				
			2e NCR 10-011									
Part No	D117- 762.	- ०५। PAR #:	Fault Category: Procl. Ski	dlubes NCR: Yes	No DQ	A:	Date: _ <i>_</i>	6.02.04				
	Resoluti	ion:	Disposition:	QA: N/C	losed:	O	Date:					

Resolution: re-work Disposition: re-work QA: N/C Closed:

NCR: 5	4881	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
10.02.04	250	Upon ASSembly of the D3508-9 wear plate, it was noticed that the holes in the tube were too narrow and causing the wearph to lift in the center when tightened.	te fosiur	Drill jig fuct hole angle slightly changed (camein) with use, due to mild o.D coushing on the tube from bending DT8974 is Reworked.	500 9. 000	10.02.04	DSIUL	10.02.04			
		R.C. Tooling.	10.52.01	on the 2 most fuct holes on the 03508-9 wearphate, Slot the holes, square, to max 0.060 (or as necessary), to allow the bolts to tighten	10211	Sylvalus	10.52,57 05/042	10.02.00			
			10. when	with out any bending upof the	10-2-1	Solutio	10.02.04 Por OSI 042	1,0.02.00			



January 5, 2010 8:03:27 AM

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Revision ID:

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Start Date:

05/01/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:



Run

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



QC:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan

Code

Stop

Reject

Qty



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

260

OC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

Draw

Number

Accept

Qty

270

Packaging Packaging

Packaging

Memo

Memo

0.00

0.00

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

280

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/18 AJ -MK 10-2-18

WORK ORDER CHANGES							
Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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QA:	Date: _						
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Verification	Approval	A				
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Picklist Print

January 5, 2010 8:03:31 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC



Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

If I KeVD. add pic.	ssuic wash DD o	/. I Z. I I	vermed oy.								
Replacement Item ID	Mfg/ Purch	Bin Item	Primaga [*] Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	_		Date Issued	Status
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			ST	28672		36 36		_			
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	Manufactured	No			190	Each	37.0000	1.0000	·	7	7
			Loca	<u>ition</u>	Loc	<u>Qty</u>	Loc Code				
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44445

37

37

Page 1

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval . Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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January 5, 2010 8:03:31 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC



Start Date: 05/01/2010

Required Date: 18/01/2010

Required Qty: 1.00 Start Qty: 1.00

Cresponent Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary ************************************	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty The Issum	Date Issued	Status
D3584-1		Manufactured	No			190	Each	2.0000	1.0000	*.		

Web

		Warehouse	Lo	c Qty	Loc Code		
		Location					
		Main Warehouse			1355205	1	W 10/1/13
		LG		2	())		_
		54349		2			_
Manufactured	No		190	Each	199.0000		

D2973

Cross Bolt Spacer Warehouse Location Main Warehouse ST

> No Manufactured

Loc Qty Loc Code 199 14636 199 Each 34.0000 1.0000 190

BE 10/01/14



Loc Qty Loc Code Warehouse Location Main Warehouse ST 34 34 44456

D3662-3

W/O:		10-10-10-10-10-10-10-10-10-10-10-10-10-1	WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву		Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Description of NC			Section B V			Verification	Approval	Approval		
DATE	SIEP	Section A	Initial Action Descrip Chief Eng Chief Eng		Sign & Date		Section C		Chief Eng	QC Inspector		
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Picklist Print

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item Name:

D11

D117-762-041

Replacement Skidtube

Comments:

Parent Item:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC



Start Date: 05/01/2010

Start Qty: 1.00

Required Date: 18/01/2010

Page 3

Status

Required Qty: 1.00

Compagn Item ID/	Replacement	Mfg/	Bin	Primary	ast	Route	Unit of	Qty on	Remaining	Qty (S.).
	Item ID	Purch	Item	Location		Seq ID	Measure	Hand	Qty To Pick	Issued
D3662-1		Manufactured	No	- -	ý <u>.</u>	190	Each	24.0000	3.0000	

No

No



Crossbolt Spacer

Warehouse	<u>Lo</u>	c Qty	Loc Code		
Location					
Main Warehouse					
ST		24			
39022		6			1/1
39585		18		<u>_3_</u> &£	10/01/14
	240	Each	2,717.000 36.0000		, ,

ALS4-1032-130 Purchased

Insert

Warehouse	Lo	c Qty	Loc Code	
Location				
Main Warehouse				
ST /		2717		
110511		2717		
	240	Each	40.0000	2.0000

36 Bl 10-01-21.

ALS4-428-165 Purchased

Inserts

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	40	
6989	40	

2 bp 10-01-21.

W/O:			WORK ORDER CHANGES							
DATE	STEP	 PR	OCEDURE CHANGE		Ву	Date	Qty	Approval, Chief Eng / Prod Mgr	Approva QC Inspecto	
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Part No):	 PAR #:	Fault Category:	NCF	R: Yes	No DQ	 A :	Date:		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	3	Verification	Annasial	Approval QC Inspector					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng						
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· · · · · · · · · · · · · · · · · · ·													

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Item ID

Parent Item Name: Replacement Skidtube

Comments:

Item Nani

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Manufactured

Manufactured

Manufactured

Purch

Replacement Mfg/

Bin Primary Item Location

No

No

No

Lesi La ation Route Seq ID

250

250

250

Unit of Measure

Each

Oty on Hand 55.0000 1.0000

Loc Code

Remaining Otv To Pick

Start Date: 05/01/2010

Start Qty: 1.00

Issued

Date Status Issued

Required Date: 18/01/2010

Required Qty: 1.00

D2965

Componer em ID/

Cap, 105 Skidtube

Warehouse Location

Main Warehouse

FP4

52057 N

Loc Qty

55 55 Each

1.0000

-B/10-21-21.

D3508-3

Wearplate

Warehouse Location

FP21

51386

Loc Otv

7.0000

Loc Code

Main Warehouse

7 7 Each

3.0000

16/10-01-21. 1.0000

D3508-9

Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 46596

1 1 10-01-2h

W/O:			W	ORK ORDER	CHANGES					
DATE STEP PROCEDUR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector		
								B 2		
		•		× :						
Part No) :	PAR #:	Fault Cat	egory:	No	CR: Yes	No DQ	A:	Date: _	
	R	lesolution:	Dispositi	on:	Q	A: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CO	NFORMANC	E (NCF	()			
DATE	STEP	Description of NC		Corrective Act			Verific	cation	Approval	Approval
	SILF	Section A	Initial Chief Eng		escription f Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
				•						
				W						

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Replacement Skidtube Parent Item Name:

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Manufactured

Manufactured

Start Date: 05/01/2010

Start Qty: 1.00

Required Date: 18/01/2010

Required Qty: 1.00

1/bl/10-01-211

Component It D/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last a C	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	ि Date ै Issued	Status
D3558-3		Manufactured	No			250	Each	12.0000	1.0000			211 31
					•							



Gasket

Warehouse	<u>Lo</u>	c Oty	Loc Code		
Location					
Main Warehouse					
ST /		12			- Bl 10-01-01.
51391		12			1 15x 10-01-01.
	250	Each	15.0000	1.0000	·
					the state of the s



Gasket

Warehouse	<u>Lo</u>	c Qty	Loc Code	
Location				
Main Warehouse				
ST /		15		
50928		15		
	250	Each	13.0000	1.0000



Gasket

Warehouse	Loc Qtv	Loc Code	
Location			
Main Warehouse			
ST	13		
40399	1		- Bl 10-01-21.
42254	12		- 1 the wood

	•				•			
W/O:			WO	RK ORDER CHANGES			, in	·
DATE	STEP	PRO	Ву	Date Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector		
						ļ.		
Part No	:	PAR #:	Fault Cate	gory: Ne	CR: Yes	No DQA :	Date: _	
	Res	olution:	Disposition	n: Q	A: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR	3)		
DATE	0750	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign &	Section C	Chief Eng	QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC	Description of NC Corrective Action Section B					Approval					
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector					
		,											
				10-2-20									
	1		1 1		1			1					

Status

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Replacement Skidtube Parent Item Name:

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Manufactured

Manufactured



Start Date: 05/01/2010

Start Qty: 1.00

Required Date: 18/01/2010

Required Qty: 1.00

1∰ Tuce

√ §ssued

Component Ite	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Locatic	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued
D3558-13		Manufactured	No			250	Each	9.0000	1.0000	



Gasket

	Warehouse		c Qty	Loc Code		
	Location					
	Main Warehouse					
	ST /		9			- Al 11-N-21
	40400		4			1 /s/ 10-0-21.
	42255		5			
No		250	Each	7.0000	1.0000	



Wearplate

Warehouse	Loc	c Qty	Loc Code	
Location				
Main Warehouse				
ST		7		
40398		2		
40398 46880 √		5		
·	250	Each	5.0000	1.0000

Wearplate

D3508-13

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
ST ,	5	
42252	5	

1 pl 10-01-21

-fgl 10-01-21

W/O:		WORK ORDER CHA	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		;					,	
						· _		
		•				·		
	<u> </u>							

Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)				
		Description of NC		Corrective Action Section B		Verification	Annaval	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		
								-	
			*						
					•				
				<u></u>					

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC



Start Date: 05/01/2010

Start Qty: 1.00

Required Date: 18/01/2010

Required Qty: 1.00

Component Item In Item Name

Replacement Mfg/ Item ID

Purch

Primary Item Location Last Location 🦝

Route Seq ID

250

Unit of Measure

Oty on Hand

Remaining **Oty To Pick**

Qty Issued tate Status Sued

D3492-051

Manufactured

Manufactured

No

No

Each

20.0000

Loc Code

2.0000

Plug Assembly

Location

Warehouse

Main Warehouse ST

20 20 250 Each

Loc Qty

16.0000

Loc Code

2 bf 10-01-01 2.0000

D3492-049

Plug Assembly

Warehouse	Loc Qty
Location	
Main Warehouse	
ST	16
40356	1
44632	15

2 Bl 15-01-21.

W/O:			WORK ORDER	CHANGES			**********		•
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
									
								•	
Part No):	PAR #:	Fault Category:	NCR	: Yes	No DQ	A:	_ Date: _	
		Resolution:	Disposition	04.1	NI/C C	locodi		Deter	

NCR:			ER NON-CONFORMANO	ANCE (NCR)					
	T	Description of NC		Corrective Action Section B		Verification	A	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		
7									
								<u>.</u>	

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

Parent Item Name:

D117-762-041

Replacement Skidtube

Item ID

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Manufactured

Purchased

Primary Component Item ID/ Replacement Mfg/ Item Location Purch

No

Last Location Route Seq ID

Loc Qty

Unit of Qty on Measure Hand

68.0000

Loc Code

Remaining Qty To Pick

6.0000

Start Qty: 1.00

Start Date: 05/01/2010

Issued

Date 4 Status Issue

Required Date: 18/01/2010

Required Qty: 1.00

6 BR 10-01-21

D3492-053

Item Name

Plug Assembly

Warehouse Location

Main Warehouse FP

54641 Main Warehouse ST

44063

250

2 Each

2

4,915.000 2.0000

AN960JD10L

Washer

Loc Code Warehouse Loc Qty Location Main Warehouse ST 4915 101291 16 104885 25 105793 236 109632 174 110985√ 4464

2 fil 10-01-21

W/O:		WORK ORDER CI	RK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector		
		· · · · · · · · · · · · · · · · · · ·							

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:		Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Approval	Annuoval	
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector	
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			Sur					-	
		1							
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January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC



Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

placement Mfg/ tem ID

Purch

Purchased

Purchased

Bin Primary Item Location

No

No

Last Location 1 # dute g ID

250

Unit of Measure

Each

Oty on Hand

1,195.000 28.0000

Remaining Oty To Pick Issued Date Issued ** Status

AN3C4A

f ibeibii	***	Hibai	HII	111
BOLT				

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse		-	
ST	1195		
112314	13		
112720	12		
112724	3		
112829	1		
112991	2		
113121	64		
113226	586		
113359	14		
113422	500		
	250 Ea	669.0000	2.0000

28 BR 10-0-21.

AN3C5A



Bolt

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
st 113644	669	
111424	8	
111707	69	
112314	1	
113121	291	
113149	300	

2 Bl 10-01-21.

W/O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector
		•			****		
•							

Part No:	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						
	STEP Description of NC Section A		Corrective Action Section B			Annuaval	Annessal
SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
	STEP	STEP Description of NC	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng	STEP Description of NC Section A Chief Eng Corrective Action Section B Initial Action Description Chief Eng Chief E	STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Chief Eng Chief Eng Chief Eng Corrective Action Description Chief Eng Ch	STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Ch

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

acement Mfg/ i∰m ID

Purch

Purchased

Bin Primary Item Location

No

Last Location

Rouse Sec 30

250

Unit of Measure

Each

Qty on Hand

795.0000 2.0000

Remaining Qty To Pick Issued Issued

= BL 10-01-01.

28. Bl 10-01-21

Status

AN960JD416L

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	795	
105078	4	
107008	54	
108583	40	
110153	297	
112492	400	

AN960C10L

Purchased

No

250

Each

416.0000 28.0000



washer

Warehouse	Loc Qty	Loc Code
NASIH9CO3332 Proceedion	113888	
FG	100	
103585	100	
Main Warehouse		
ST	316	
112116	156	
112612	160	

Dart Aeı	rospace	e Ltd							
W/O:			WO	RK ORDER CHANG	ES				······································
DATE	STEP	PROCEDURE CHANGE				Ву	Date Q	ty Approval. Chief Eng / Prod Mgr	Approval QC Inspector
		The state of the s		·			-	*	
								•	
Part No	:	PAR #:	Fault Categ	ory:	_ NCR	: Yes N	o DQA : _	Date: _	
	R	esolution:	Disposition	:	QA:	N/C Clos	sed:	Date: _	
NCR:		V	VORK ORDE	R NON-CONFORMA	ANCE	(NCR)	-		
		Description of NC		Corrective Action Sect	ion B		Verification	on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		QC Inspector

NCh:											
	T	Description of NC		Corrective Action Section B	Verification	Approval	Annuarial				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
	į										
							:				

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

Parent Item Name:

D117-762-041

Replacement Skidtube

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Purchased

Purchased

No

No

Start Date: 05/01/2010

Required Date: 18/01/2010

Required Qty: 1.00 Start Qty: 1.00

Component Item ID/ Item Name	Radacement Itan ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rou (Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Statu	
AN4-4A	. 9	Purchased	No		-	250	Each	119.0000	2.0000				

Bolt

Warehouse	<u>I</u>	Loc Qty	Loc Code		
Location					
Main Warehouse					
ST		119			
101291		3			11
106918 🖊		1			- 10-01-01.
108138 🗸		58			2 H Wall.
111295		57			
	250	Each	60.0000	6.0000	

NAS1611-012

O-RING

Warehouse	Lo	c Qty	Loc Code	
Location				
Main Warehouse				
ST /		60		
108673		60		
	250	Each	20.0000	2.0000

6 BA 10-01-21

NAS1611-015

O-RING

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	20	
107178	20	

BR 10-01-21.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval, Chief Eng / Prod Mgr	Approva QC Inspector
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				İ	• ,		·
Part No):	PAR #: Fault Category: N	CR: Ye	s No DQ	A:	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approva				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
					į						
							44	,			

January 5, 2010 8:03:32 AM

Work Order ID: 54881

Parent Item:

D117-762-041

Parent Item Name: Replacement Skidtube

Component Item ID/

Comments:

IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Purchased

Replacement Mfg/ Item D

Purch

Bin Primary Item Location Last Location

113524

Route 4 Seq ID Unit of Qty on Measure Hand

Each

50

Remaining

117.0000 2.0000

Qty To Pick Issued

Date tatus Issued

Required Date: 18/01/2010

Required Qty: 1.00

Item Name NAS1611-016

O-RING

Start Date: 05/01/2010 Start Qty: 1.00

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse	`	
ST	117	
107178 🗸	17	
112492	50	

<u>a</u>BL 10-01-21.

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
•						·				
						:				

Part No:	PAR #:		Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B				A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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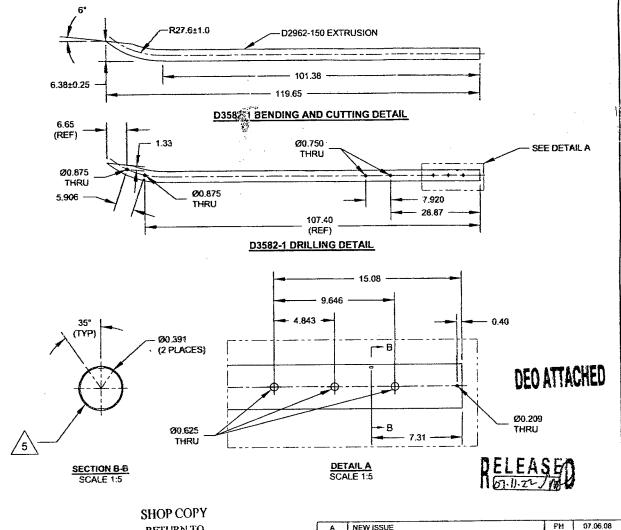
PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

Qty	Part Number	Description
×	D3582-041	SKIDTUEE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CRGSS BOLT SPACEG
2	03492-049	PLUG ASSEMBLY
2	D3492-051	FLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY ?
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
-;	D3556-11	GASKET
1	D3558-13	GASKET
7	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD1CL	WASHER
2	ANSGOJD416L	WASHER

GENERAL NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED
- 3) WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 615 AFTER BENDING.
- 5) USE DART DRILL TEMPLATE DT6900 TO LOCATE AND DRILL @0.297 HOLES (36)
 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36) PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 6) DO NOT INSTALL ANGCAA BOLTS AND ANGEOC10L WASHERS IN INDICATED LOCATIONS.
- 7) FINISH
 - A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING

 - B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 C) ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 54/88/

A NEW ISSUE SY DATE REV. DESCRIPTION DART AEROSPACE USA, INC DESIGN PORT HADLOCK, WA DRAWN CHECKED DRAWING NO. REV. A D3582 SHEET 1 OF 2 MFG, APPR. SCALE TITLE APPROVED **BK 117 SKIDTUBE ASSEMBLY** 1:20 DE APPR. COPYRIGHT & 2007 BY BART AEROSPACE USA, INC. DATE 07.06.08

BN 10-1-5

8

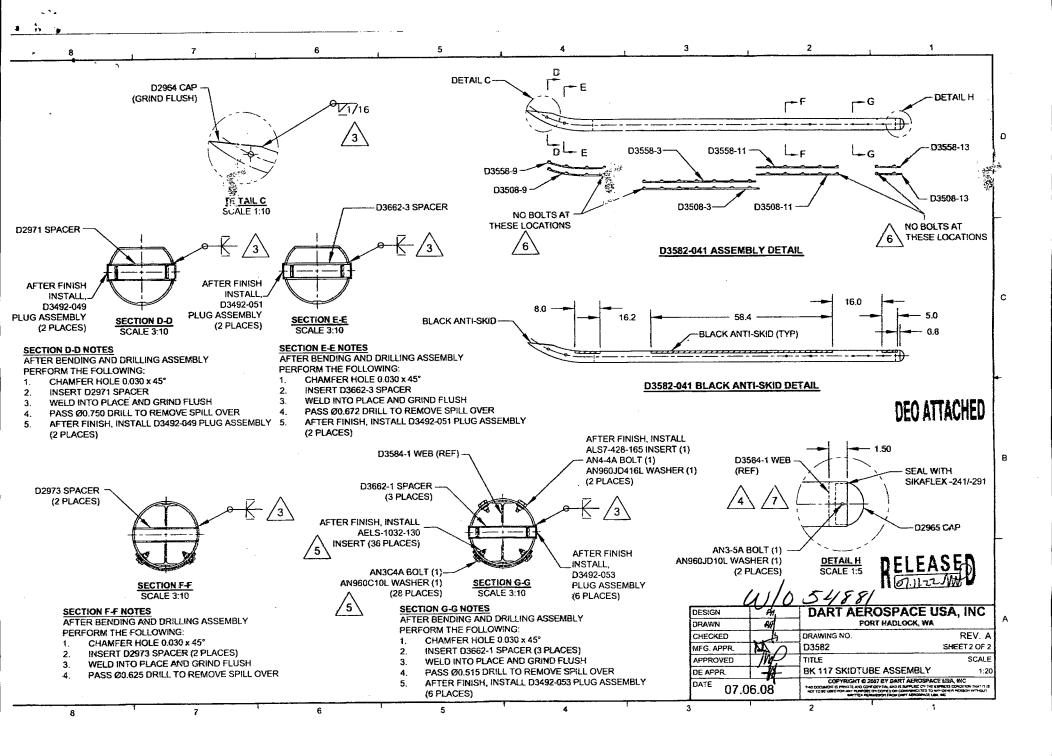
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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE	STEP	P PROCEDURE CHANGE		EP PROCEDURE CHANGE BY		PROCEDURE CHANGE By Date		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	,										
						·					

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:	:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Approval	Approval	
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	

			1		1				



	WORK ORDER CH			₹		
STEP	PROCEDURE CHANGE		Date	Qty	Approval , Chief Eng / Prod Mgr	Approval QC Inspector
					.	
				-		
	STEP		STEP PROCEDURE CHANGE By		STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

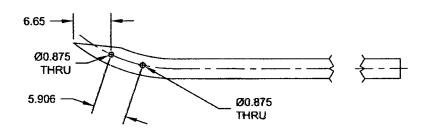
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Approval	pproval Approval	
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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DRAWING	NO. TE	TLE	REV. A DART AERO	SPACE USA, INC	C D.E.O. NO.	SHEET NO.	SCALE
D3582	• B	K 117 SKIDTUBE ASSEM E L'	Y ENGINEE	ERING ORDER	D3582-A-1	SHEET 1 OF 1	NTS
DRAWN	PH	CHECKED	MFG. APPR.	E A	A/M/	DE APPR.	
DATE	09.04.06	DATE 64.04.00	, DATE	09.04.06	ATE MIJUDH	DATE 09.04-0	6

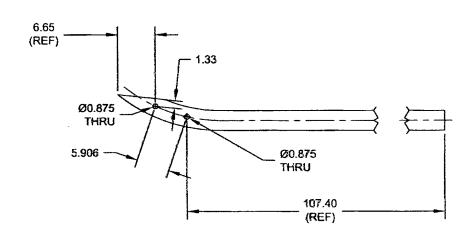
W/0 54881

FOR EASE OF MANUSACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GET DEFLECTOR: UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



RELEASED

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WHITTEN PERMISSION FROM DART AEROSPACE USA, MC.

W/O:				WORK ORDER CHANGES									
DATE	STEP	STEP PR		STEP PROCEDURE CHANGE	PROCEDURE CHANGE By	PROCEDURE CHANGE	PROCEDURE CHANGE By Date		PROCEDURE CHANGE By Date Q		Qty	Qty Approval Approval Chief Eng / Prod Mgr QC Inspec	
		·											
									•				
Part No	:		PAR #:	Fault Category:	NCR: Yo	es No DQ	A:	Date:	•				
	R	esolution:		Disposition:	QA: N/C	Closed:		Date: _					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B		Verification	Ammuoval	Ammanal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
								1	

NO.	330	
INO.	$-\alpha\alpha(C)$	

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name 2 and silver		
Name: Darday Elliott		
Job number: 54161		
Part number: Dil7-762-041		
Description: 17 sk.d tub	· e	
Welding Process: Tig[/] Mig[]		
Base materiel: Aluminium		
Current: AC[,] DC[]		
TEST RE	OUTREM	ENTS AND RESULTS
120111	2011(1)11	ENTO AND RESULTS
X7* ¥	- 4	
Visual:	pass[/]	
Penetration:	pass[√]	fail[]
UNACCEPTABLE		
Cracks:	pass[√]	fail[]
Undercut:	pass[/]	fail[]
Pin holes:	pass[/]	
Overlap (cold lap)	pass	+ 3
Porosity (surface):	pass[1	<u> </u>
Coloration:	pass[~]	fail[]
<i>ĝ</i>	r - L J	[]
$II \cap I$		
Qualifier / c/	Date of Te	est Coupon 09/12/15
0 11 0111.		/ /
Welder Barlay that	Date of To	est Coupon <u>09/12/10</u>
		, ,

The above named individual is qualified in accordance with AWS D17.1.2001 to weld